

Work Order ID 52305

Tuesday, September 22, 2009 2:32:59 PM



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Item ID: D2739	Accept		Setup	Start	
Revision ID: D				Stop	
Item Name: 350 I Beam					
Start Date: 9/23/2009	Start Qty: 10.00		Cust Item ID:		
Required Date: 10/9/2009	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL MW</u>	Date: <u>09/09/24</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev D								

100 0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739. □2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 □3-Use uni-bit to open holes to finish size as per Dwg D2739. □4-Bevel Fwd end of extrusion and Deburr holes and ends. □5-Dburr

10X

Q

MB 09-09-28

110 0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

27 S 09/09/28

10X

Q

120 0.00



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

10X

Q

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Item ID: D2739

Accept

Revision ID: D

Item Name: 350 I Beam

Start Date: 9/23/2009 Start Qty: 10.00

Required Date: 10/9/2009 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10 ϕ - AWM 9-9-2809/09/29 ϕ
R 09-9-28

Picklist Print

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Work Order ID: 52305



Parent Item: D2739RevD



Parent Item Name: 350 I Beam

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-5-108RevD1		Manufactured	No			100	Each	268.0000	10.0000			

Extrusion 'I Beam' thin

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

268

29985

1

38589

19

47814

248

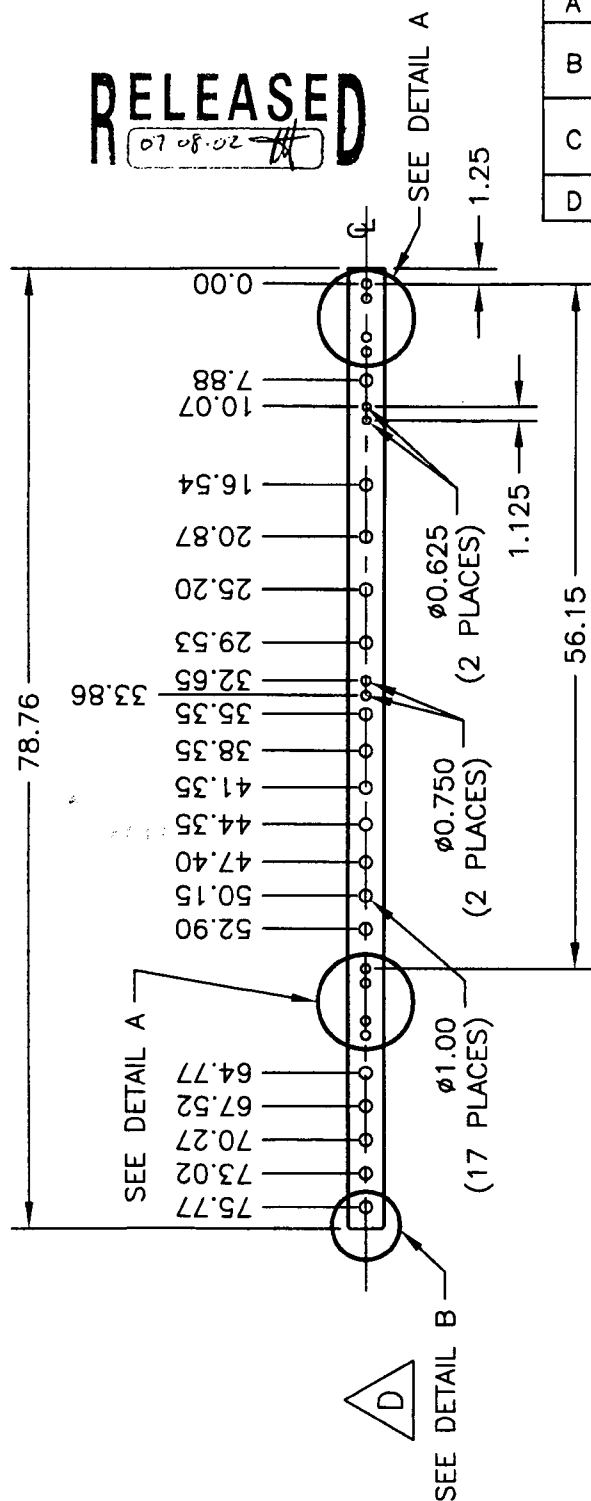
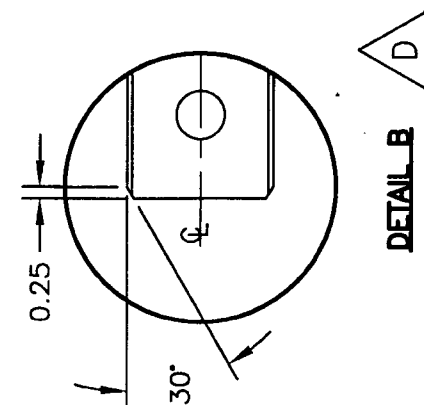
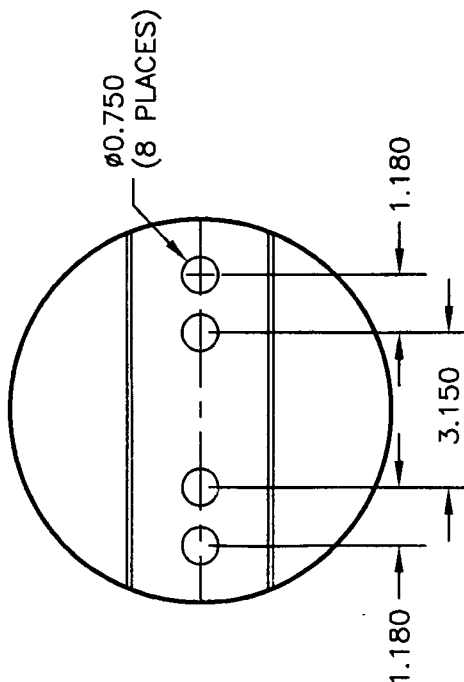
104

MB 09-09-28

✓

DARTW10: 52305
CZ09/09/28**RELEASED**
07.08.02

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D2739	REV. D SHEET 1 OF 1
DATE 07.05.29	TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B	

**D2739 WEB****DETAIL B****DETAIL A****NOTES:**

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT ϕ

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